

What is claimed

1. A procedure for the manufacture of a special tile from a basic tile which is single fired, porcelain stoneware, double fired, porous single fired or similar, including the following phases:
  - a) the cutting of the basic tile according to a pre-determined cutting plan transversal to a decorated front surface to create a special tile;
  - b) the chamfering, bevelling or rounding of at least one edge of the special tile to form a profile with a pre-determined surface geometry and finish;
  - c) the cold application, to the area of the worked profile, of a painting product which acts as a superficial or decorative finish, by means of a painting apparatus;
  - d) the drying of the special tile for a pre-determined period of time in an environment with a controlled temperature.
2. A procedure as claim 1, wherein the drying phase takes place in a controlled environment at 20°C for a period of approximately two hours.
3. A procedure as in claim 1, wherein the painting apparatus includes an airbrush of a manual type.
4. A procedure as in claim 1, wherein the cold painting product includes a double component polyurethane product.
5. A procedure as in claim 1, wherein after the chamfering phase and before the glazing phase, two further intermediary phases are envisaged:
  - e) the application to the area of the worked profile of a neutral epoxidic pigmented primer which acts as fixative, by means of a painting apparatus.
  - f) leaving the special tile to rest for a pre-determined period of time in a environment with a controlled temperature before the application of the painting product.
6. A procedure as in claim 5, wherein the resting phase takes place in a controlled environment at 20°C for period of approximately two hours.

sub D1 7 - A line for special tiles produced from basic tiles including, in order:

- a cutting station for the basic tiles;
- a chamfering, bevelling or rounding station for at least one of the edges of the special tile cut from the basic tile, to form a profile with pre-determined surface geometry and finish;
- a first station, including an apparatus with a manual airbrush, for the application of a primer which acts as a fixative to the area of the worked profile;
- a ventilated resting station where the special tile is left at approximately 20°C for approximately two hours;
- a second station, including an apparatus with a manual airbrush, for the cold application of a painting product for the surface finish to the area of the worked profile;
- A ventilated drying station where the special tile is left at approximately 20° for approximately two hours;

Sub b1 8. A special tile created from a basic tile, wherein it includes a front surface with a decoration and finish determined in the basic tile manufacturer's plant, and at least one chamfered, bevelled or rounded edge, which defines the worked profile, preferably with a 'bird's beak', cold painted with a painting product to obtain a surface finish which is generally similar to or co-ordinated with the decoration and the finishing of the front surface.